

August 25, 2009 1:35:29 PM

Item ID:

D2651-1

В **Revision ID:** 

Item Name: Plug

Required Date: 8/25/09

Start Date:

8/25/09

**Start Qty: 250.00** 

Req'd Qty: 250.00

Reference:

Approvals:

**Process Plan:** 

QC:

Operation

**Description** 

Date: 07-8-25 Tooling:

Date:

0.00

0.00

Accept

SPC (Y/N):

Set Up/

**Run Hours** 

Draw Number

**Cust Item ID:** 

**Customer:** 

Draw Rev.

Date:

Date:

Plan Code

Accept Qty

Reject Qty

Run

Setup Start

Stop

Start

Stop

Reject Number

Insp. Stamp

Work Center 1D Draw Nbr

Sequence ID/

**Revision Nbr** 

D2651

100

Rev B

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL Memo

1- Turn as per Folio FA219 and Dwg D2651112- Deburn

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

251

120

QC

Quality Control

Memo

QC8- Inspect parts - second check

S\$ 09/09/11

W/O:			WORK ORDER (	CHANGES								
DATE	STEP	PR	PROCEDURE CHANGE By Date Qty			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No <b>DQ</b>	<b>A</b> :	Date: _					
	Resolution:		Disposition:	QA: N/C	Closed:		Date: _					

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Annuoval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
								<u> </u>

#### Work Order ID 51530

August 25, 2009 1:35:29 PM

Item ID:

D2651-1

**Revision ID:** В

Plug Item Name:

**Start Date:** 

8/25/09

QC:

**Start Qty: 250.00** 

Reference:

Required Date: 8/25/09

Req'd Qty: 250.00



Accept



Run

Setup Start



Stop

**Cust Item ID:** 

**Customer:** 

**Approvals:** 

**Process Plan:** 

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date: Start

Stop



Sequence ID/ Work Center ID

130



Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr ias per dwg D2651

Set Up/ **Run Hours** 

Draw Number

Draw Rev.

09/09/16

Plan Code

Accept Oty

Reject Qty

Reject Insp. Number Stamp

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

14112260

0.00

Memo (Only larger section necessary): START TIME: 3200 FINISH

TIME:

8:30 AM



W/O:		WORK ORDER CH	ANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	18	PAP #· Fault Category:	NCP: Voc	Na BO	A -	Deter	1				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:
NCD.	W	ORK ORDER NON-CONFORMA	NCF (NCR)	· · · · · · · · · · · · · · · · · · ·

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
5.475	0777	Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
	7									

### Work Order ID 51530

В

August 25, 2009 1:35:29 PM

Item ID:

D2651-1

**Revision ID:** 

Item Name: Plug

Required Date: 8/25/09

**Start Date:** 

8/25/09

Req'd Qty: 250.00



Accept



Setup Start



Stop



Start Qty: 250.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

QC:

Process Plan:

Date: Date:

Tooling: SPC (Y/N):

Date: Date: Run

Start

Stop



Sequence ID/ Work Center ID

160

QC

Quality Control

**Operation Description** 

QC3- Inspect Part Finish

Set Up/ **Run Hours**  Draw Number Draw Rev.

Plan Qty Code

Accept **Qty** 

Reject Reject Number

Insp. Stamp

Memo

02-09-16

0.00

170

Packaging

Packaging

Memo

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/16 hd

W/O:			WO	RK ORDER CHANG	ES				· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PR	OCEDURE CHAP	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									,		
Part No: PAR #: Fault Categor		ory:	_ NCF	R: Yes	No <b>DQ</b>	A:	Date:				
Resolution:			Disposition	:	_ QA:	N/C CI	sed:		Date:		
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR	)				
DATE	CTED	Description of NC		Corrective Action Secti	on B		Verific	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector	
								***			

#### **Picklist Print**

August 25, 2009 1:35:29 PM

Work Order ID: 51530

D2651-1RevB

Parent Item Name: Plug

Comments:

Parent Item:

Component Item ID/ Replacement Mfg/ Item Name Item ID Purch M6061T6R0.500 Purchased

6061-T6 Round Bar .500"



No

**Start Date: 8/25/09** 

Start Qty: 250.00

Required Date: 8/25/09

Required Qty: 250.00

Date

Issued

Remaining Primary Qty Last Route Unit of Qty on Location Measure Hand Qty To Pick Issued Seq ID Item Location

100

10.5526

70.1500

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
MAT	70.15		
110532	36	/	
111448	34.15	DA 3/dm 10.552	6

Status

W/O:			WO	RK ORDER CHANGES	3				, , , , , , , , , , , , , , , , , , , ,
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition	) <b>:</b>	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCF	₹)			
DATE	CTED	Description of NC		Corrective Action Section	В	Verific	cation	Approval Approv	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign and Date	🙎   Secti		Chief Eng	QC Inspector
						i.			
				*****		1			
1								1	1

DART AEROS	SPACE LTD			1	Work Order:	5	530
Description:					Part Number:	n S	651-1
Inspection Dwg	: Rev:					P	age 1 of 1
	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	X	First Artic	F	Proto			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
0,060	±0.005	0.060					
0.050×20°	to.010/+1/20	0.050x26°	/	[ *			
0.375	±0.010	0.375					
0,060	±0,005	0.060					
0.438	±0.010	0.436					
0.305	to.000/-0,002	0.302	1,				
0.090	10,000/-0,002	0.090	V				
0.045	to,000/-0,002	01045					
51010	7 - 7 - 7 - 7					····	
							···
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	1						
						<u></u>	
		<u> </u>		<u> </u>			
Measured by:	1 Chir	Audited by:	18		Prototype App	roval:	N/A

Measu	red by:	DID	Audited by:	Prototype Approval:	N/A
	Date:	09/09/10	Date: 09/09/11	Date:	N/A
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	

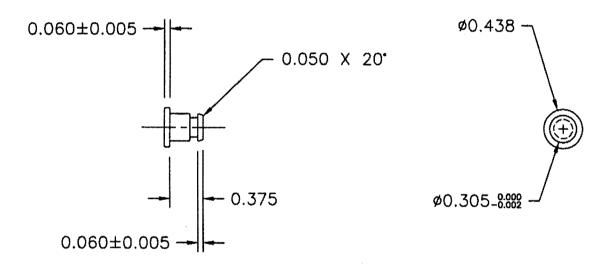




DESIGN	A DRAWN BY	•	OSPACE LTD , ONTARIO, CANADA
CHECKE	D APPROVED	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE	( <del>- 1</del>	TITLE	SCALE
03.13	2.19	PLUG	1:1
Α	97.03.25	NEW ISSUE	
в	03.12.19	ADD POWDER COA	T. MS28775-008

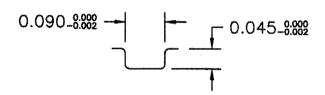
## RELEASED 03.12.19

#### D2651-1 PLUG:





### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER 3/16 ID, 5/16 OD, 1/16 WIDTH (PARKER 2-008, MS28775-008 OR EQUIVALENT)

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